

Work Order ID 68009

Tuesday, April 05, 2011 10:53:18 AM

Page 1

Item ID: D4323-24

Accept

Revision ID: PRELIM

Item Name: Access Panel, RH

Setup Start

Stop

Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 4/5/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan: *mf*

Date: *11-04-05*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4323

PA7 PA83

100

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

BB
11/04/05

105

0.00

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QS1022 Kydex

Temp:

Time IN:

Time OUT:

440° 150°
6:00 PM 11/04/04
7:00 11/04/05

BB
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




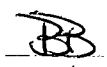


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Page 2

Item ID: D4323-24	Accept		Setup	Start	
Revision ID: PRELIM					
Item Name: Access Panel, RH				Stop	
Start Date: 4/5/2011	Start Qty: 1.00		Cust Item ID:		
Required Date: 4/5/2011	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform	0.00							
Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA108 using tool DT9733 Dwg Rev: <u>PAS</u> Folio Rev: <u>A</u>	0.00							 11/04/05
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect part for proper formation and texture								 11/04/05
130 	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									 11/04/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68009

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Item ID: D4323-24

Accept



Setup Start



Revision ID: PRELIM

Item Name: Access Panel, RH

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

Wh
11/04/05

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

1

BB 11/04/05

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

-inspector to Part
Don only
Sulox102

(40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 4

Item ID: D4323-24

Accept



Setup Start



Revision ID: PRELIM

Item Name: Access Panel, RH

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: *REALME*

0.00



Packaging

Memo

0.00

Packaging

11/6/61

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*RD
2370*

POSITIVE RECALL

EFFECTIVE *11/04/05*AUTH *u*

RELEASED

DATE

MF 11-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:53:15 AM

Page 1

Work Order ID: 68009

Parent Item: D4323-24

Parent Item Name: Access Panel, RH



Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA New Issue 11-03-01 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

therm

Loc Qty

787.2912

Loc Code

116576

787.2912

11/04/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

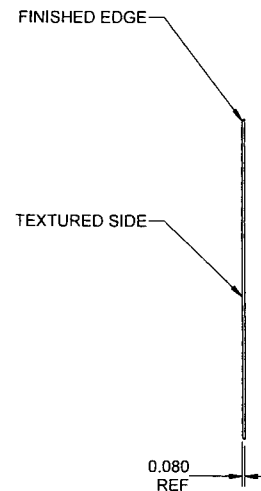
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D4323-23 ACCESS PANEL, LH
D4323-24 ACCESS PANEL, RH (OPPOSITE)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.68 lb
- 8) TOOLING: THERMOFORM -23/-24 PART PER MOLD DTXXXX.
TRIM PER MOLD LEAVING FINISHED EDGE
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040



DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA8
MFG. APPR.		D4323	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD.	
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DART AEROSPACE LTD		Work Order:	68007
Description: ACCESS PANEL 3A.		Part Number:	04323-24
Inspection Dwg: 4323	Rev: PA8	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB	Date:
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.58"	±0.30"	10.55	✓		1H 03	
18.00"	±0.30"	17.85	✓		1H-05	
9.78"	±0.30"	9.78	✓		1H-03	

Measured by: JB	Date: 4/24/05
Audited by: J & M PA 3 Day	Date: 11/04/06
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10-04-14